

Wednesday, 3/29/2006 1:04:06 PM
Linda Lacelle

Process Sheet

| | | | | |
|-------------------------|--|--------------------|----------------------------|------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | BASKET BASE ASSEMBLY (350) | |
| Job Number : | 26390A | | | |
| Estimate Number : | 10189 | | | |
| P.O. Number : | N/A | Part Number : | D2221 | |
| This Issue : | 3/29/2006 | S.O. No. : | N/A | |
| Prsht Rev. : | NC | Drawing Number : | D2221/D2235 | |
| First Issue : | N/A | Project Number : | N/A | |
| Previous Run : | 26256C | Drawing Revision : | F/B1 | |
| | | Material : | N/A | |
| Written By : | SEE COMMENT Below | | Due Date : | 4/5/2006 |
| Checked & Approved By : | | | Qty: | 1 Um: Each |
| Comment : | Est Rev:J 05.09.02 Added D3442-1KJ/JLM | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|--------------------------|
| 1.0 | D31661 | Basket Hoop |
| | | |
| Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D3166-1 RIB <u>B26259</u> | | |
| CPL 06-03-30 | | |
| 2.0 | D22323 | Basket Hinge |
| | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2232-3 Hinge bracket <u>B25239</u> | | |
| CPL 06-03-30 | | |
| 3.0 | D2325 | Support Gusset (350 Bask |
| | | |
| Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D2325 Support Gusset <u>B25687</u> | | |
| CPL 06-03-30 | | |
| 4.0 | D23273 | Spacer Bushing |
| | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2327-3 Bushing <u>B24874</u> | | |
| CPL 06-03-30 | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 26390A

Part Number: D2221

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------|------------------|
| 5.0 | D2581 | Mounting Bracket |
|-----|-------|------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B25834

CPL 06.03.30

| | | |
|-----|--------|------|
| 6.0 | D34421 | Shim |
|-----|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B23544

CPL 06.03.30

| | | |
|-----|--------------|--------------------------|
| 7.0 | M304EX07516F | Expanded Metal Flat Stai |
|-----|--------------|--------------------------|



Comment: Qty.: 39.6900 sf(s)/Unit Total: 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal M100518

CPL 06.04.04

| | | |
|-----|----------------|--------------------------|
| 8.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 29.4000 f(s)/Unit Total: 29.4000 f(s) M100138 → 18,88"

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M100138 → 192"

M100023 → 74,13"

CPL 06.03.29

| | | |
|-----|-------------|------------------------------|
| 9.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

06.04.07

CPL

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/04/18
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DA 06/04/10

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/11

①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06/04/11

①

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M100 480

Expiry date: 11/2006

JAP 06/04/15

①

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/04/18

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Job Completion



U 06/04/18

| W/O: | | WORK ORDER CHANGES | | | | | |
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